

Date: Monday, 08/06/2009 1:12:02 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ANGLE		
Job Number	: 48413					
Estimate Number	: 10198					
P.O. Number	:			Part Number	: D21752	
This Issue	: 08/06/2009		S.O. No. :	Drawing Number	: D2175 REV E	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type	Drawing Revision	: E	
Previous Run	: 35342			Material	:	
Written By	:			Due Date	: 15/06/2009	
Checked & Approved By	: <u>JUL 09.06.08</u>			Qty:	10	Um: Each
Comment	: Est E 04.06.09 Rerformat KJ/RF Est Rev:F 06-04-28 Manufactured on Water Jet JLM Est Rev:G As per Rev E 06-11-22 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S063	2024-T3 .063 sheet	
		Comment: Qty.: 0.4958 sf(s)/Unit Total : 4.9581 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)	Batch: <u>111787</u> <u>IB 9-6-9</u>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2175 Dwg Rev: <u>E</u> <u>IB 9-6-9</u> Prog Rev: <u>E</u>	(14)
		2-Deburr if necessary	<u>IB 9-6-9</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>IB 9-6-9</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>208/06/10</u> (14)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack	<u>11/08/08</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 48413

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

BB 09/06/10

14

7.0 QC5 INSPECT WORK TO CURRENT STEP



16-06-11 (13)



PRC

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 09/06-11

13

9.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

BB 09/06/11

13

10.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: GA

BB 09/06/11

13

11.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/11 (13)

Job Completion



MF  
09-06-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/06/11	7.0	1 part Scrap. Several blowouts around a hole.  QC: Process	QSI442	Scrap : destroy : no replace.	83 09/06/11	09/06/11	QSI442	09/06/11

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>48413</b>
<b>Description:</b> Angle	<b>Part Number:</b>	<b>D2175-1/-2</b>
<b>Inspection Dwg:</b> D2175 <b>Rev:</b> E		<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: AB	Audited by: S	Prototype Approval: N/A
Date: 9-6-9	Date: 07/06/10	Date: N/A

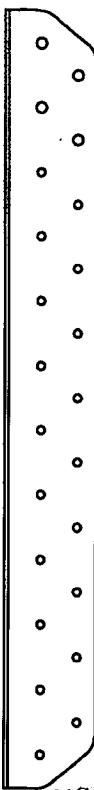
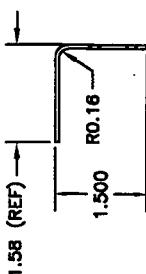
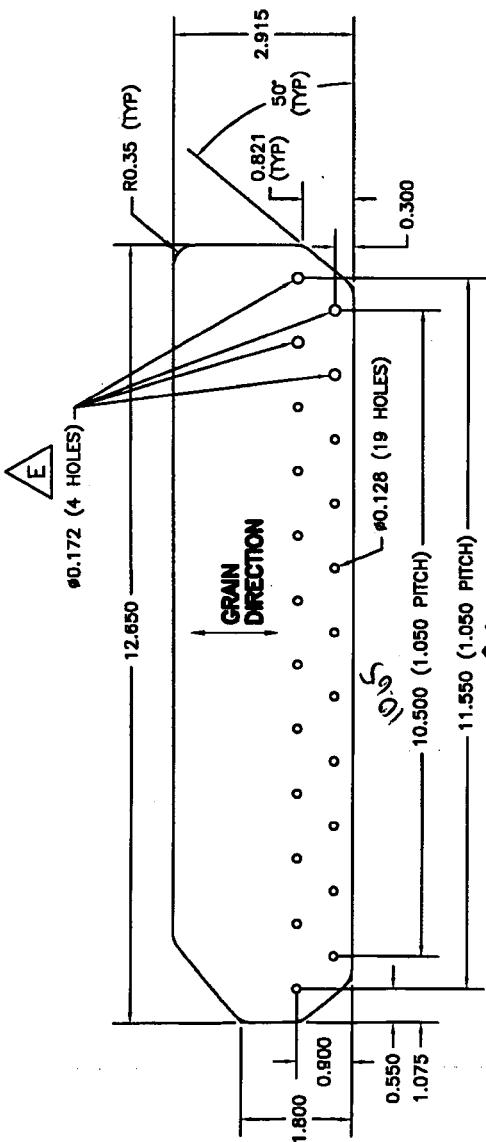
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

**DART**

DESIGN RF	DRAWN BY CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED H	DRAWING NO. D2175	REV. E SHEET 1 OF 1
DATE 06.09.25		TITLE ANGLE	SCALE 1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	CHANGED DIMENSION	
C	00.09.11	UPDATE FINISH SPEC	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC HOLE DIA TO $\phi 0.172$ , 4 HOLES	

RELEASED  
06.10.13

5/20/03



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4893

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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